

Date: Friday, 11/11/2005 2:41:03 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BLADE
Job Number	: 24750	Part Number	: D2741
Estimate Number	: 10327	Drawing Number	: D2741 REV B2
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 11/11/2005	S.O. No.	: N/A
Prsh Rev.	: NC	Drawing Revision	: B2
First Issue	: N/A	Material	: N/A
Previous Run	: N/A	Due Date	: 11/30/2005
Written By	: SEE COMMENT BELOW		
Checked & Approved By	: SEE ABOVE DATE & USER		
Comment	: Est D 00.11.15 Removed P/O turning - in house process E C		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M4130NB0500X03000	4130 Bar 0.5 x 3.0"
	Comment: Qty: 1.2118 f(s)/Unit Total: 24.2361 f(s) 4130 BAR 0.5 x 3.0" Material: 4130 steel bar 0.50" x 3.00"	Batch: M19397
2.0	BAND SAW	BAND SAW
	Comment: BAND SAW Cut blanks 13.850" long +0.063" -0.000"	J.L 06.01.04 20
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine per folio FA108	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	J.L 06.02.05 20

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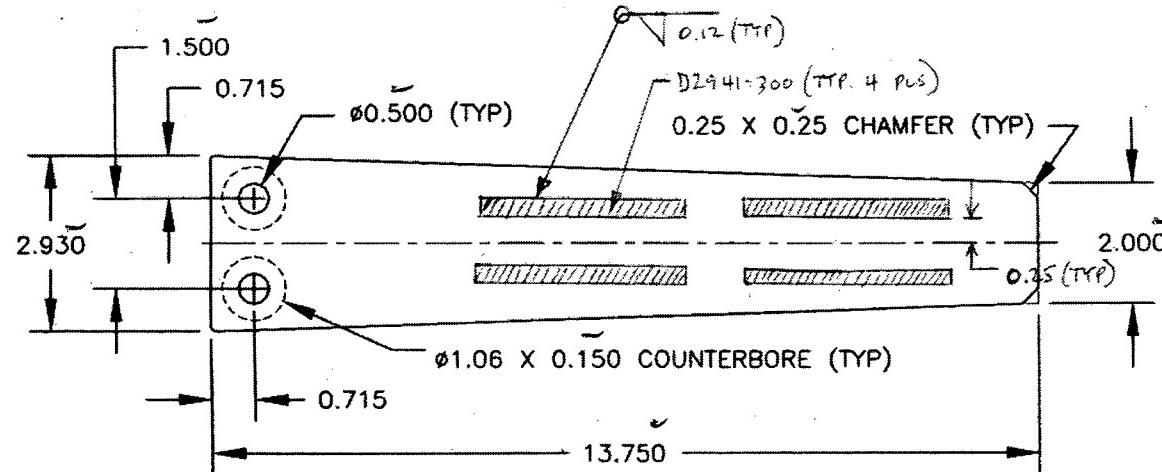
Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: BLADE
Job Number: 24750		Part Number: D2741
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK		M8 06/02/06 20
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr 2-Bend per Dwg D2741		FF 06.02.24 SB 06/02/13 20
7.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		J 06.02.14 20
8.0	PG	PURCHASING
Comment: PURCHASING Issue P/O: 00000578 Harden material as per Dwg D2741 Min. Ultimate Tensile Strength = 152 ksi (30-40 HRC) Min. Yield Tensile Strength = 141 ksi Test report or Certification required		fl 06/02/15
9.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Receive and Inspect for transit damage Ensure Test report or Certification attached		C 06/02/28 20
10.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		J 06.03.01 20
11.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3		a.m. 06-03-03 20

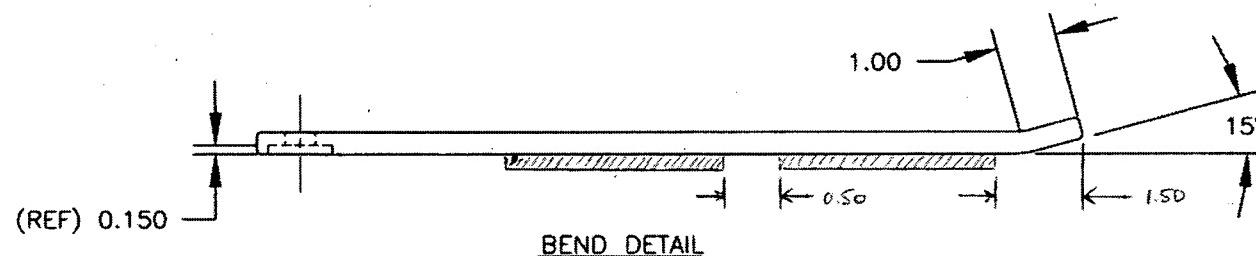
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Job Number: 24750		Part Number: D2741
Job Number:		
Seq. #:	Machine Or Operation:	Description :
12.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION  P-6/3/6 20
13.0	PACKAGING 1 	PACKAGING RESOURCE #1  P-6/3/6 (20)
14.0	DC 	DOCUMENT CONTROL  P-6/3/6 (20) D 06/03/07
Job Completion 		W 06/03/07



FLAT PATTERN



BEND DETAIL

MATERIAL: AISI 4130 STEEL 0.375 THICK

MIN. ULTIMATE TENSILE STRENGTH = 152 ksi (34-40 HRC)

MIN. YIELD TENSILE STRENGTH = 141 ksi

FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

BREAKAWAY HARP EDGES 0.030 TO 0.060

1.00
D2941-300, WELD 2941-300 (4) AS SHOWN ABOVE. REMOVE POWDER COAT SURFACE OF D2941-300

-043, WELD 7560 HARDCOAT ROD INSTEAD OF D2941-300

RELEASED
18-11-03
DS

DART

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MADE

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
44	JP	FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED	APPROVED	DRAWING NO.
44	PC	D2741
DATE		REV. B
98.09.01		SHEET 1 OF 1
A	98.04.16	SCALE
B	98.09.01	1:3
B1	01.01.31	BLADE
B2	01.02.25	ADD Rockwell Hardness

#010225
CP 01.02.26
B2

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 10, 2005
07:04 am

Work Order No	:	0024750	Department Code:		
Project Name	:	D2741	Burden Flags	:	NNNNNNNN
Project For	:	WK547	WO Status	:	Open
Work Order Type	:	Main	Invoice State	:	Not Invoiced
Main WO Number	:		Invoice Date	:	
House Part Number	:	D2741	Invoice Number	:	
Description	:	Blade	Invoice Amount	:	0.00
Manufactured	:	Yes			
Amount Req'd	:	20			
Amount Done	:	0	Order Entry No	:	
Start Date	:	11-09-05	OE Value	:	0.00
Est. Finish Date	:	11-24-05	Est Margin	:	0.000%
Act. Finish Date	:		Actual Margin	:	0.000%
Drawings Reqd	:	No			
Ok for Approval	:				
Approval Rec'd	:		\$0 Posted to Finished Goods		

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	:	0.00	0.00	0.00	0.00
Engineering Hours	:	0.00	0.00	0.00	0.00
Engineering Cost	:	0.00	0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00	0.00
Production Cost	:	0.00	0.00	0.00	0.00
Packaging Hours	:	0.00	0.00	0.00	0.00
Packaging Cost	:	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00	0.00
OverHead Cost	:	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	0.00	0.00	0.00
CNC	:	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00	0.00	0.00	0.00
Misc.	:	0.00	0.00	0.00	0.00
Burden	:	0.00	0.00	0.00	
Total Cost	:	0.00	0.00	0.00	
Margin	:	0.000	0.000		
Selling Cost	:	0.00	0.00		

	Estimated	Actual
Labour Hrs/Amount Done	:	0.00
Profits/(Loss)	:	0.00

DART AEROSPACE LTD	Work Order: 24750
Description: blade	Part Number: D2941
Inspection Dwg: D247 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article

1

Prototype

Measured by:	JL
Date:	06-02-05

Audited by:	M8
Date:	06/02/05

Prototype Approval:	N/A
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	



PACKING SLIP

OAK 72793-1

HEAD OFFICE
1371 SPEERS ROAD, OAKVILLE, ONTARIO
CANADA L6L 2X5
TEL: (905) 827-4171 FAX: (905) 827-7489

QUEBEC DIVISION
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

GST No.: R105468102

02/24/2006

MM / DD / YYYY

PAGE : 1

1DAR01
BILL TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
02/24/2006		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
104525		COD

LN	PART NO	DESCRIPTION	UOM	QTY ORDERED	QTY SHIPPED	B/O QTY
01	D2741	BLADE - C 206102129	EA	20	20	0
		Process Specifications: Procedure: 4161 HARDENED PER DWG. D2741 TO 152 KSI MINIMUM HRC 34-40 MATERIAL: 4130 B24750				
02	MC	MINIMUM CHARGE		1	1	0

No claims for shortage in weight or count will be entertained, unless presented within 5 working days after receipt of materials by customer.



VACUUM BRAZING • HEAT TREATING • SPECIAL PROCESSING • FURNACE EQUIPMENT



HEAT
TREATING



VAC AERO
INTERNATIONAL INC.

RELEASE NOTE

GST No.: R105468102

OAK 72793-1

HEAD OFFICE
1371 SPEERS ROAD, OAKVILLE, ONTARIO
CANADA L6L 2X5
TEL: (905) 827-4171 FAX: (905) 827-7489

2009 WYECROFT ROAD, UNIT B
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CANADA H4S 1C5
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BILL TO: 1DAR01
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
02/24/2006		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
104525		COD

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D2741	BLADE	EA	20	20	<p>Process Specifications: Procedure: 4161 HARDENED PER DWG. D2741 TO 152 KSI MINIMUM HRC 34-40 MATERIAL: 4130</p> <p><i>B24750</i></p> <p><i>100% HARDNESS TESTED 20 pls. 35/36 HRC</i></p> <p><i>06/03/01</i></p>
					<p><i>06/03/01</i></p> <p><i>VA.I.O. TH. 25 Q.C.</i></p>

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

Sanna Freeman
Authorized Q.C. Inspector



VACUUM BRAZING - HEAT TREATING - SPECIAL PROCESSING - FURNACE EQUIPMENT